

Date: Tuesday, 1/15/2008 9:49:59 AM  
 User: Kim Johnston

## Process Sheet

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : SADDLE ASSEMBLY  
 Job Number : 36775B-1  
 Estimate Number : 11180  
 P.O. Number :  
 This Issue : 1/15/2008 S.O. No. :  
 Prsht Rev. : NC Part Number : D2282043  
 First Issue : 1/1 Type : SMALL MED FAB Drawing Number : D2282 REV E  
 Previous Run : 35451B Drawing Revision : E  
 Written By :  
 Checked & Approved By :  
 Comment : Est Rev: A Removed from 9 Dig: 05-12-02 JLM

Qty: 100 Um: Each

Additional Product

Job Number:

Seq. #: Machine Or Operation: Description:

1.0 D2281 Jack Saddle

Comment: Qty.: 1.0000 Each(s)/Unit Total: 100.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 1 D2281 Saddle B355471 → 21x  
 B36824 → 76x

2.0 D22827 Tube

Comment: Qty.: 2.0000 Each(s)/Unit Total: 200.0000 Each(s)

Pick:

Qty Part Number Description Batch  
 2 D2282-7 tube B355474 → 84x  
 B34183 → 3  
 B35638 → 109x

3.0 LARGE FAB 1 LARGE FABRICATION RESOURCE 1

Comment: LARGE FABRICATION RESOURCE 1

1-Weld as per D2282-043 Saddle Assembly

Grind chamfers and ensure full penetration.

A/R ER316L SS Filling Rod M106762

Dwg Rev: E

4.0 QC9/5 VISUAL WELDING INSPECTION

Comment: VISUAL WELDING INSPECTION

3.1 Small fab

- grind weld and beburn holes

08/03/20





User:

# Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: SADDLE ASSEMBLY

Job Number: 36775B

Part Number: D2282043

Job Number:



Seq. #:

Machine Or Operation:

Description :

50

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Tumble

60

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

70

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location:

ST266

80

QC2

FINAL INSPECTION/W/O RELEASE



Comment: FINAL INSPECTION/W/O RELEASE

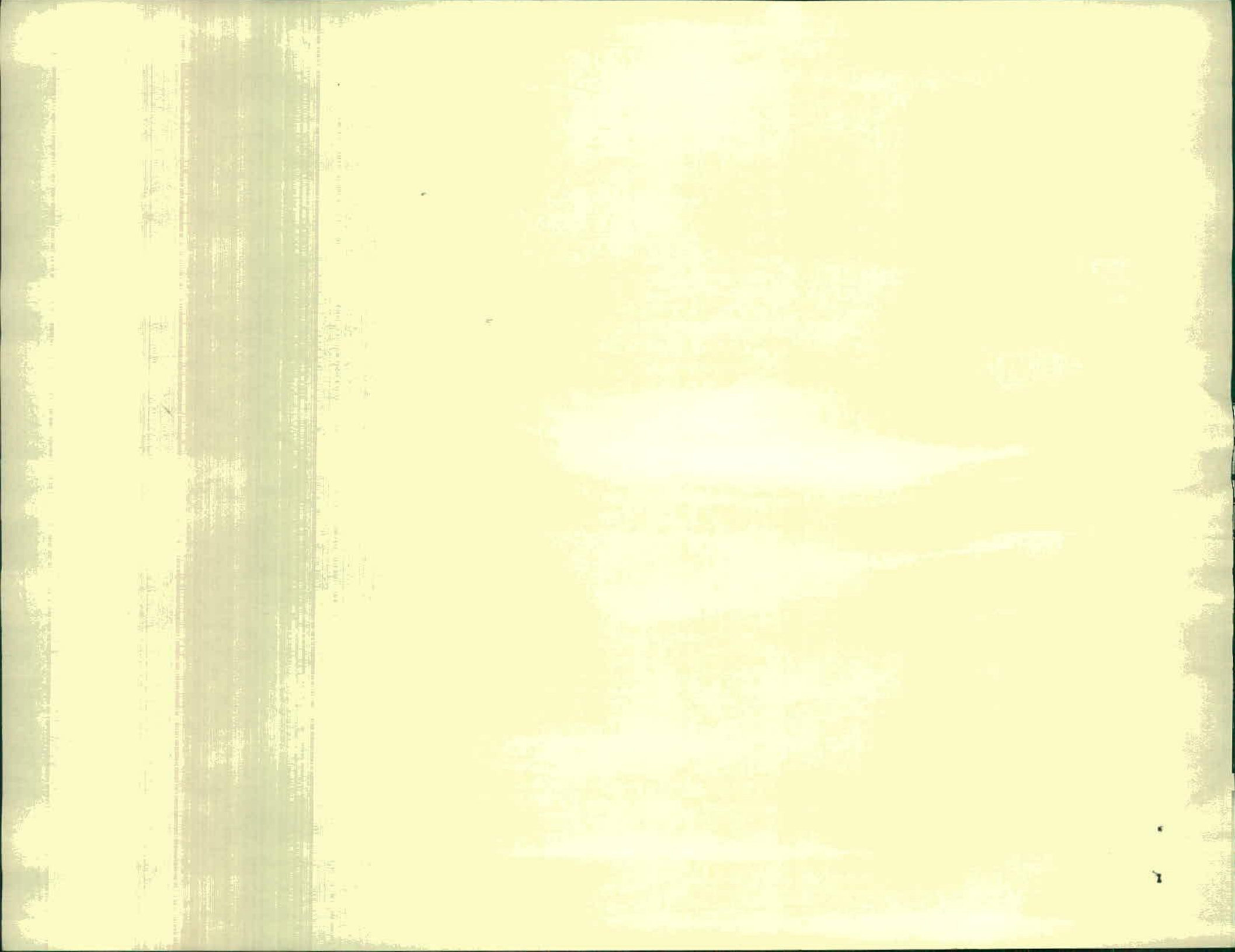
Job Completion



mf 08-03-31

W

080402  
A

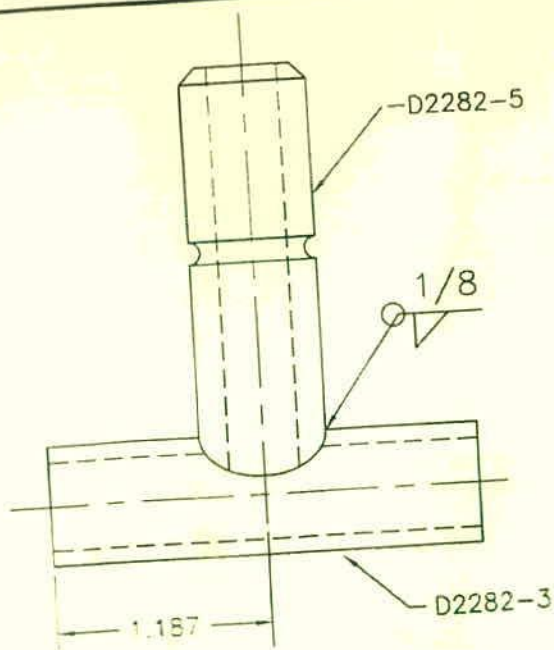




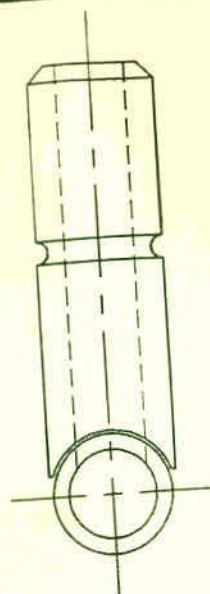


DESIGN BW	DRAWN BY <i>[Signature]</i>	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA	
CHECKED <i>[Signature]</i>	APPROVED <i>[Signature]</i>	DRAWING NO. D2282	REV. E SHEET 2 OF 2
DATE 05.06.07		TITLE HANDLE TUBES	SCALE 1:1

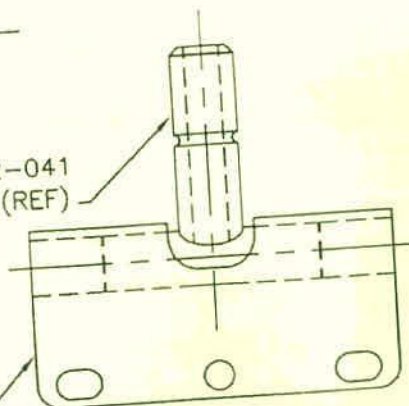
RELEASED  
*[Signature]*  
05/09/16



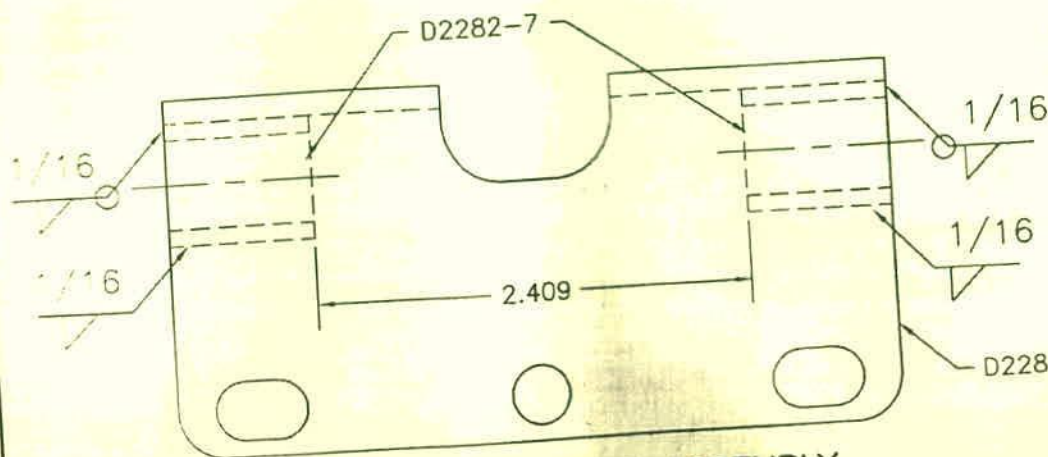
**D2282-041 'T' ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004



D2282-043  
(REF)



**GENERAL ASSEMBLY**  
SCALE 1:2



**D2282-043 SADDLE ASSEMBLY**  
WELD ASSEMBLY PER DART QSI 004

SHOP COPY  
RETURN TO  
ENGINEERING  
UNCONTROLLED COPY  
SUBJECT TO AMENDMENT  
WITHOUT NOTICE  
WORK ORDER  
NO. **36775B**

Copyright © 1994 by DART AEROSPACE LTD

THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE LTD.

